

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

H:\FORMS\Quality Assurance\approved QA\NCRWO RevE

Thursday, September 01, 2011 7:38:16 AM

Page 2

[illegible]

[illegible][illegible][illegible]

Reference:

[illegible]

Date: _____

**Insp.
Stamp**

RESEARCH

Sp 11/12/24

RESEARCH DESIGN

73



3 BL 11-11-24.

Hand Finishing

Dart Aerospace Ltd

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Thursday, September 01, 2011 7:38:16 AM



Accept

**Setup Start**

Stop



Start Date: 8/31/2011 **Start Qty:** 3.00

**Cust Item ID:**

Required Date: 9/16/2011 **Req'd Qty:** 3.00



Customer:

Reference:

Run Start



Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00



0.00

Quality Control

3x ~~Ø~~ m/4/4/24

0.00



0.00

Packaging

③x Sep 11-11-25

0.00



0.00

Quality Control

11/11/28

UMF
11-11-25

Dart Aerospace Ltd

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Picklist Print

Thursday, September 01, 2011 7:38:13 AM

Page 1

Work Order ID: 73475



Parent Item: D4055-3



Parent Item Name: Tank Aft End

Start Date: 8/31/2011

Required Date: 9/16/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP RevA: new issue DD 10.01.08 verified by:JLM
10.11.23 now made in house DD verf:EC

IPP rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

100

sf

205.1256

1.5143

4.782



6061-T6 .063 Sheet

1811-11-21

Location

Loc Qty

Loc Code

MAT021

205.1255684

116308

26.9755684

117285

105.15

118580

73

119331

119331

(3)

Dart Aerospace Ltd

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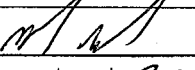
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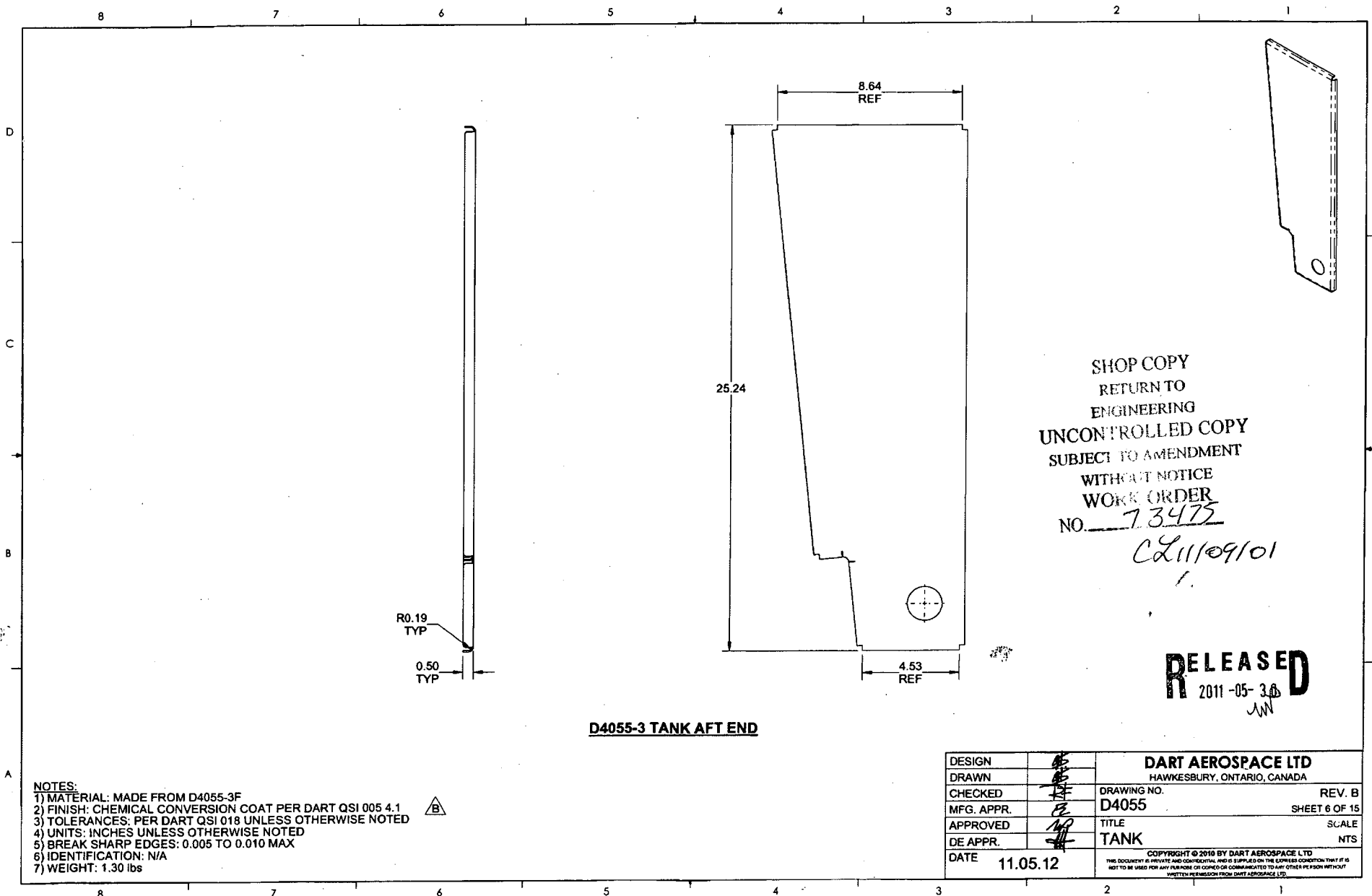
DART AEROSPACE LTD		Work Order:	73475
Description: Tank Aft End		Part Number:	D4055-3
Inspection Dwg: D4055 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.42	+/-0.030	BEWD				
0.59	+/-0.030	.592			V IB62	
9.23	+/-0.030	9.23			T IB01	
9.82	+/-0.030	9.82			T	
0.59	+/-0.030	.603			V	
0.65	+/-0.030	.65			V	
23.34	+/-0.030	23.34			T	
25.34	+/-0.030	25.34			T	
25.51	+/-0.030	BEWD			T	
25.93	+/-0.030	25.93			T	
2.22	+/-0.030	2.230			V	
5.13	+/-0.030	5.13			V	
5.72	+/-0.030	5.72			V	
6.05	+/-0.030	6.05			V	
6.12	+/-0.030	6.12			V	
7.11	+/-0.030	7.11			V	
7.17	+/-0.030	7.17			V	
7.76	+/-0.030	7.76			V	
20.96	+/-0.030	20.96			T	
21.02	+/-0.030	21.02			T	
21.55	+/-0.030	21.55			T	
25.34	+/-0.030	25.34			T	
25.40	+/-0.030	25.40			T	
0.063	+/-0.010	.060			V	

Measured by: RB	Audited by: 	Preliminary Approval:
Date: 11-11-21	Date: 11.11.22	Date:

Rev	Date	Change	Revised by	Approved
A	11.01.18	New Issue	KJ 	



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 73473

CL11/09/01

RELEASED
2011-05-30

D4055-3 TANK AFT END

- NOTES:
- 1) MATERIAL: MADE FROM D4055-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.30 lbs



DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4055	SHEET 6 OF 15
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OF COPYING OR COMMUNICATION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

